

Work Order ID 68342

Tuesday, April 12, 2011 10:06:29 AM



Page 1

Item ID: D3535-23	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearshoe				
Start Date: 4/12/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 4/18/2011	Req'd Qty: 12.00		Customer:	

Reference:

Approvals:	Process Plan:	Date: <u>4/10/11</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100		FLOW WATER JET	0.00						
Waterjet		Memo	0.00						
FLOW CNC Waterjet		1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-Deburr if necessary							
304, 040									(13)
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
QC		Memo	0.00						
Quality Control									
120		QC8- Inspect parts - second check	0.00						
QC		Memo	0.00						
Quality Control									

1311-4-18

1311-4-18

11 04 19 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68342



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Tuesday, April 12, 2011 10:06:30 AM

Item ID:	D3535-23	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	4/12/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	4/18/2011	Req'd Qty:	12.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(13X)			
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23	0.00		SB 11/04/19					=> M-L 11/04/20
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00		S 11/04/20		(13)			
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 10/10 FINISH TIME: 10/40	0.00							13 BR 11-4-21.

W/O:		WORK ORDER CHANGES					
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Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				13	0	11-4-25	
170 Packaging Packaging	Identify as per dwg & Stock Location <i>FR 21</i> Memo	0.00 0.00				13		11-4-25	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11-4-25	

11-04-25
(13)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:06:35 AM

Page 1

Work Order ID: 68342



Parent Item: D3535-23



Parent Item Name: Wearshoe

Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

67.4000

1.3615

17.19789



B11-4-18

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

67.4

116437

25.4

116623

42

116437

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68342
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	X		V 1B02	
2.000	+/-0.010	2.000	X		T 1B01	
4.750	+/-0.010	4.750	X		T	
9.500	+/-0.010	9.500	X		T	
14.250	+/-0.010	14.250	X		T	
17.750	+/-0.010	17.750	X		T	
23.140	+/-0.010	23.140	X		T	
28.530	+/-0.010	28.530	X		T	
33.920	+/-0.010	33.920	X		T	
39.310	+/-0.010	39.310	X		T	
44.700	+/-0.010	44.700	X		T	
48.200	+/-0.010	48.200	X		T	
52.850	+/-0.010	52.850	X		T	
Ø0.188	+0.005/-0.001	.191	X		V	
48.00	+/-0.030	48.00	X		T	
39.00	+/-0.030	39.00	X		T	
32.00	+/-0.030	32.00	X		T	
24.00	+/-0.030	24.00	X		T	
16.00	+/-0.030	16.00	X		T	
8.00	+/-0.030	8.00	X		T	
6.00	+/-0.030	6.00	X		T	
0.300	+/-0.010	.303	X		V	
0.300	+/-0.010	.302	X		V	
0.038	+/-0.010	.034	X		V	

Measured by:	B	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	11-4-18	Date:	11-04-19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]

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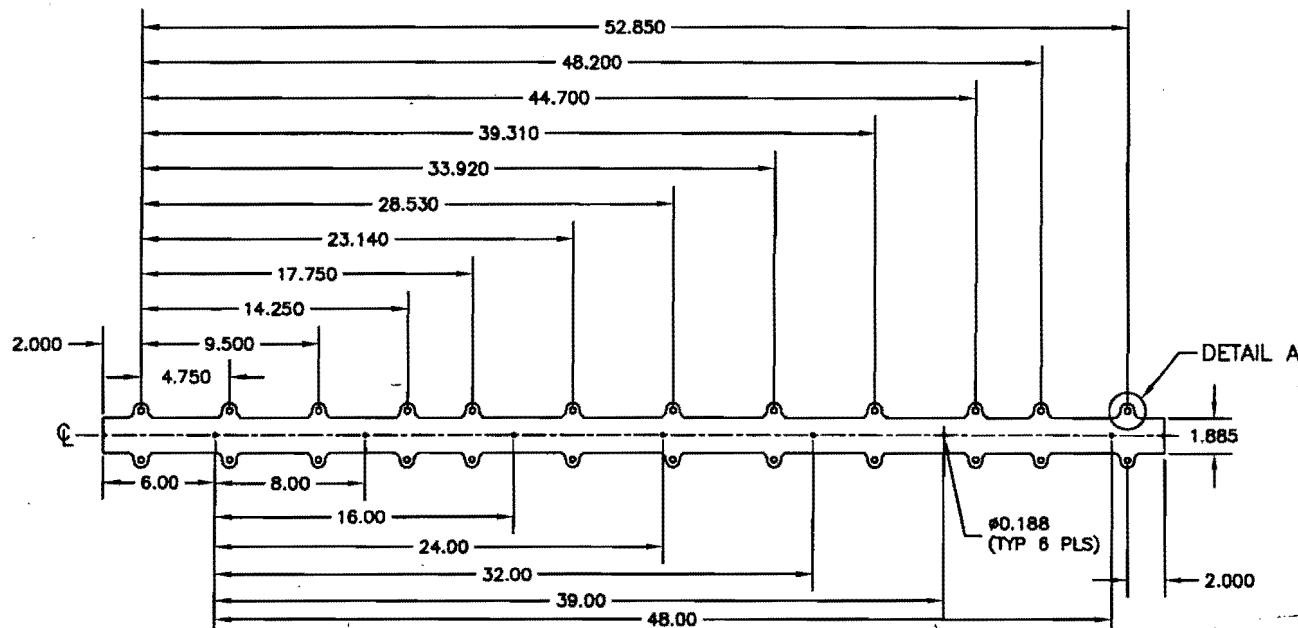
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
		WEARSHOE		SHEET 3 OF 7
		SCALE	1:10	

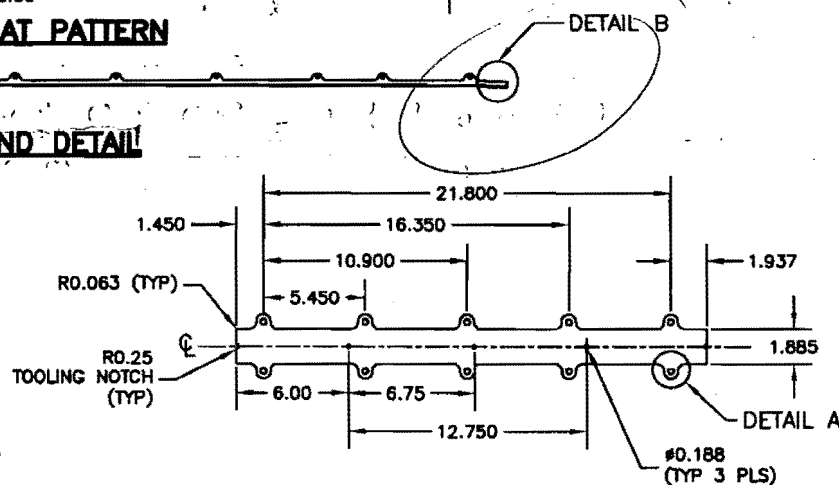


D3535-23F FLAT PATTERN

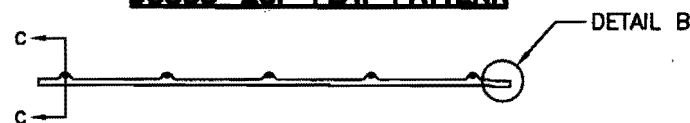


D3535-23 BEND DETAIL

SHOULDER
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68342



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART-SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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